












Date: Friday, 9/21/2007 1:00:04 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER	
Job Number : 34785		
Estimate Number : 12524		
P.O. Number : N/A	Part Number : D35341	
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : UNDER REVIEW D3534	
Prsht Rev. : NC	Project Number : N/A	
First Issue : NA Type : SMALL /MED FAB	Drawing Revision : NA A Mon/09/21 E	
Previous Run : 33299	Material : N/A	
Written By : _____	Due Date : 10/15/2007 Qty: 5 Um: Each	
Checked & Approved By : _____		
Comment : Est Rev:A New Issue 06-09.06 EC		
Additional Product		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
		
Comment: Qty.: 0.2048 sf(s)/Unit Total : 1.0238 sf(s) 2024-T3 .050 sheet Batch: M 105646 HB 07-10-1 M 105646		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D3534 Dwg Rev: A HB 07-10-1 Prog Rev: A 2-Deburr if necessary HB 07-10-1		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-10-1		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK En ALG/02 counts (XS)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. n/a		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 01/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 34785

Part Number: D35341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: MJ

Handwritten: 07-10-10

Handwritten: (5)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 7/11/11 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Handwritten: 57182*

Handwritten: 7/10/11

Handwritten: (5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 7/10/11

Job Completion



Handwritten: 7/10/11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

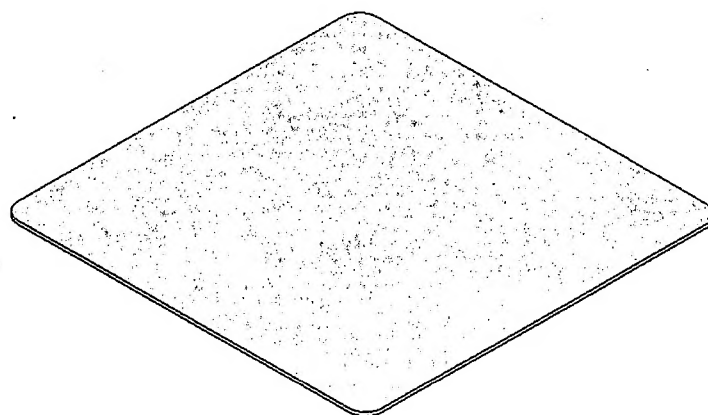
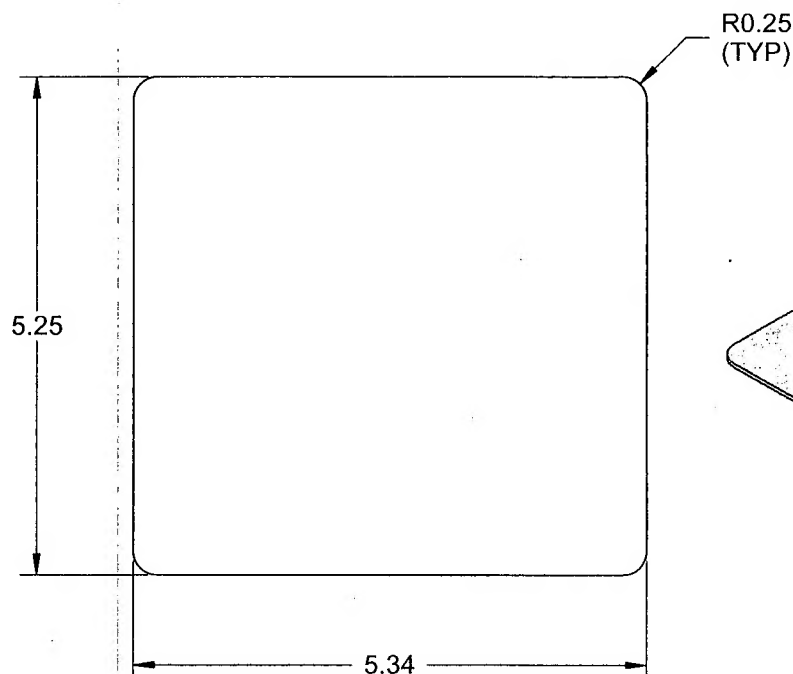
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED 	DRAWING NO. D3534	REV. A SHEET 1 OF 1
DATE 07.01.10		TITLE DOUBLER	SCALE 1:2
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE	

RELEASED
07-06-03



D3534-1 DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3534-1" USING FINE POINT PERMANENT INK MARKER

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